

Date: Monday, 11/21/2005 11:57:30 AM  
 User: Linda Lacelle

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SPACER BUSHING		
Job Number	: 24873					
Estimate Number	: 10823					
P.O. Number	: N/A		Part Number	: D23271		
This Issue	: 11/21/2005	S.O. No. : N/A	Drawing Number	: D2327 REV C		
Prsht Rev.	: NC		Project Number	: N/A		
First Issue	: N/A		Drawing Revision	: C		
Previous Run	: N/A		Material	: N/A		
Written By	: See comment below		Due Date	: 12/15/2005		Qty: 50 Um: Each
Checked & Approved By	: See comment below.					
Comment	: Est. D 05.11.02 Removed 303 SS KJ/EC					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :			
1.0	M304R0750	Inventory			
		Comment: Qty.: 0.1860 f(s)/Unit Total : 9.2978 f(s)			
		Inventory 303			
		Material: AISI 303 Round Bar Ø0.375"			
		(M304R0.375)	Batch: M16656	JML	05/11/23 50
2.0	HARDINGE	HARDINGE CNC LATHE SMALL			
		Comment: HARDINGE CNC LATHE SMALL			
		Turn per Folio FA232 and Dwg D2327			
		Deburr			
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE			
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE			
4.0	QC8	SECOND CHECK J.L			
		Comment: SECOND CHECK			
5.0	PACKAGING 1	PACKAGING RESOURCE #1			
		Comment: PACKAGING RESOURCE #1			
		Identify and Stock			
		Location: 31			
		C 05/11/23			50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 05/11/24  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action      Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: SPACER BUSHING

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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

59C 05/11/24 (50) (SP) 05/11/24/ (50)

Job Completion

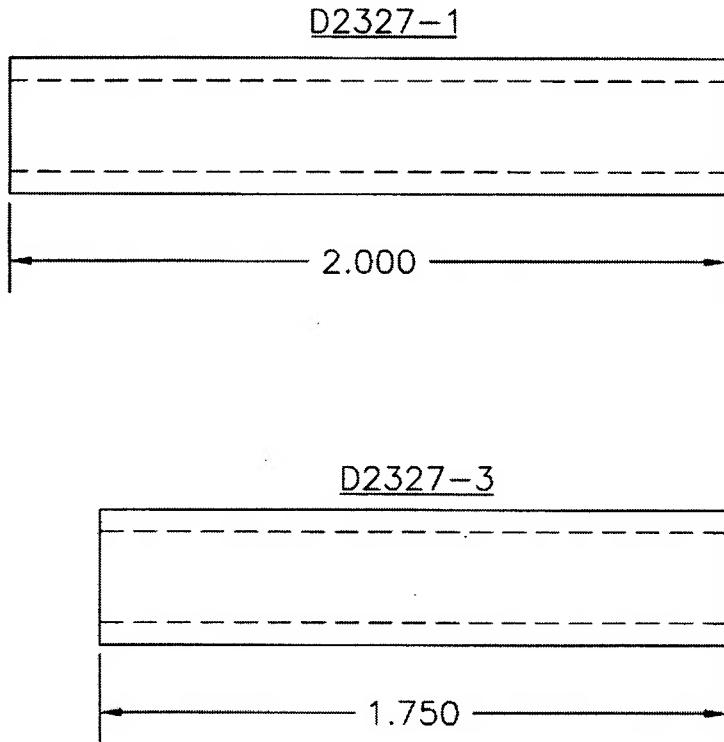


W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

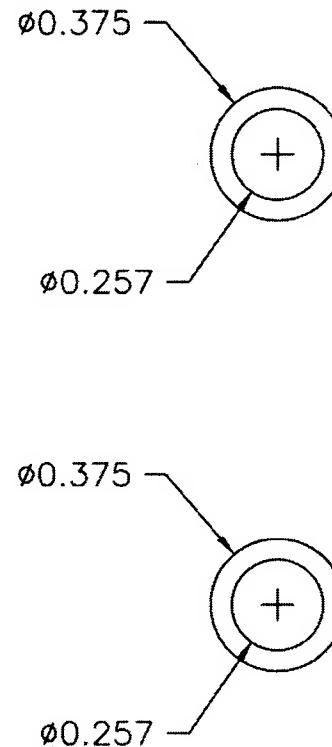
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action      Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



NOTE:

- 1) MATERIAL: Ø0.375 AISI 303 ROUND BAR (REF DART SPEC. M303R0.375) OR Ø0.375 AISI 304/316 SS 0.065 WALL SEAMLESS ROUND TUBING (REF. DART SPEC. M304TR0.375W.065)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010



**RELEASED**  
03.05.21

<b>DART</b>		<b>DART AEROSPACE LTD</b>
DESIGN BW	DRAWN BY <i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2327
DATE 03.05.13	TITLE SPACER BUSHING	REV. C SHEET 1 OF 1
A	94.12.17	NEW ISSUE
B	95.12.06	LENGTH CHANGE
C	03.05.13	303 SS SPEC ADDED

ACG/C  
ISSUED  
03.05.21

DART AEROSPACE LTD	Work Order:	
Description: Spacer Bushing	Part Number:	D2327-1
Inspection Dwg: D2327	Rev: C	Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

# X First Article Prototype

Measured by:	<i>gml</i>	Audited by:	J.L.	Prototype Approval:	N/A
Date:	05/11/23	Date:	05-11-23	Date:	

<b>Rev</b>	<b>Date</b>	<b>Change</b>	<b>Revised by</b>	<b>Approved</b>
A	03.11.27	New Issue	KJ/RF	

0000000000

Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Nov 18, 2005  
09:21 am

Work Order No : 0024873  
Project Name : D2327-1 Department Code:  
Project For : WK550 Burden Flags : NNNNNNNN  
Work Order Type : Main WO Status : Open  
Main WO Number : Invoice State : Not Invoiced  
House Part Number : D2327-1 Invoice Date :  
Description : Spacer Bushing Invoice Number :  
Manufactured : Yes Invoice Amount : 0.00  
Amount Req'd : 50  
Amount Done : 0 Order Entry No :  
Start Date : 11-18-05 OE Value : 0.00  
Est Finish Date : 12-15-05  
Act Finish Date : Est Margin : 0.000%  
Drawings Reqd : No Actual Margin : 0.000%  
Ok for Approval :  
Approval Rec'd : \$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00	0.00	0.00
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00	0.00	0.00
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00	0.00	0.00
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00	0.00	0.00
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00	0.00	0.00
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00	0.00	0.00
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00	0.00	0.00
Total Cost :	0.00	0.00	0.00	0.00	0.00
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss)	0.00	0.00